

Date: Tuesday, 16/12/2008 11:43:00 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CAM LOCK SHAFT
Job Number : 44108	
Estimate Number : 10476	
P.O. Number :	Part Number : D33933
This Issue : 16/12/2008 S.O. No. :	Drawing Number : D3393 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 39909	Material :
Written By :	Due Date : 22/12/2008 Qty: 20 Um: Each
Checked & Approved By :	
Comment : EsT A 05.02.18 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0375	303 Round Bar 0.375"
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Comment: Qty.: 0.1225 f(s)/Unit Total : 2.4507 f(s)
 Material: AISI 303 SS Rod Ø0.375
 (M303R0.375)
 Batch: M108462

mk 05/12/16

(21)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 Turn as per Folio FA509 and Dwg D3393
 Machine D3393-3 as per Folio FA509 and Dwg D3393
 Identify as D3393-3
 Deburr

mk 05/12/16

(21)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 05/12/16

(21)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA509 and Dwg D3393

mk 05/12/17

(21)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 05/12/17

(21)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/12/17

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 08/12/17

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 90

8/12/17

2/x

30

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/18

Job Completion



u 08/12/17



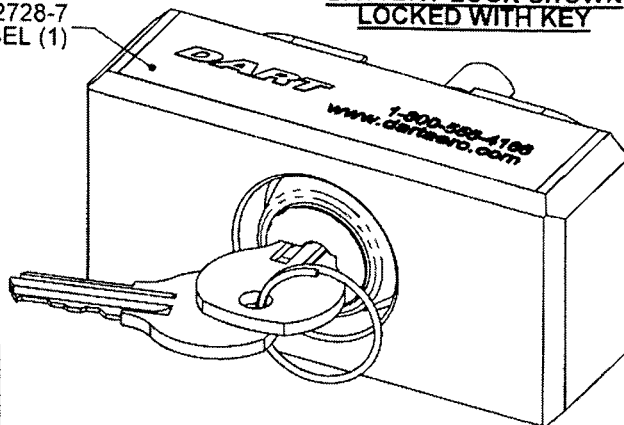
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A
DATE 05.02.08		TITLE BATTERY LOCK	SHEET 1 OF 3 SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]

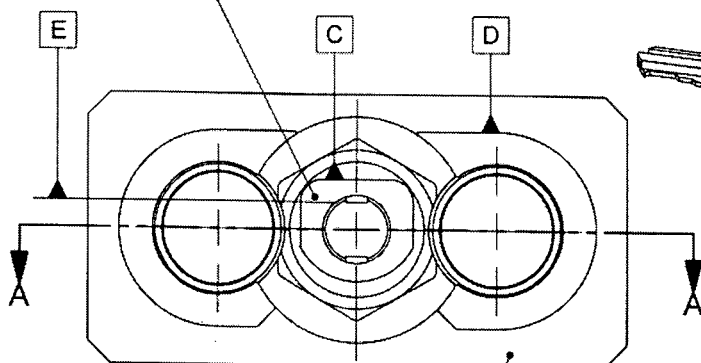
05/03/09

D2728-7
LABEL (1)

**BATTERY LOCK SHOWN
LOCKED WITH KEY**



POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWN



D3373-1
CAM LOCK
ASSEMBLY (1)

D3393-1
CASING (1)

Ø5/16" WC S/S
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2) ²/₂
AND APPLY KRAZY GLUE

D3393-3 CAM
LOCK SHAFT (1)

0.09^{+0.03}
-0.01 (2 PLACES)

TACK WELD
D3393-3 TO D3369-5

SECTION A-A

D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

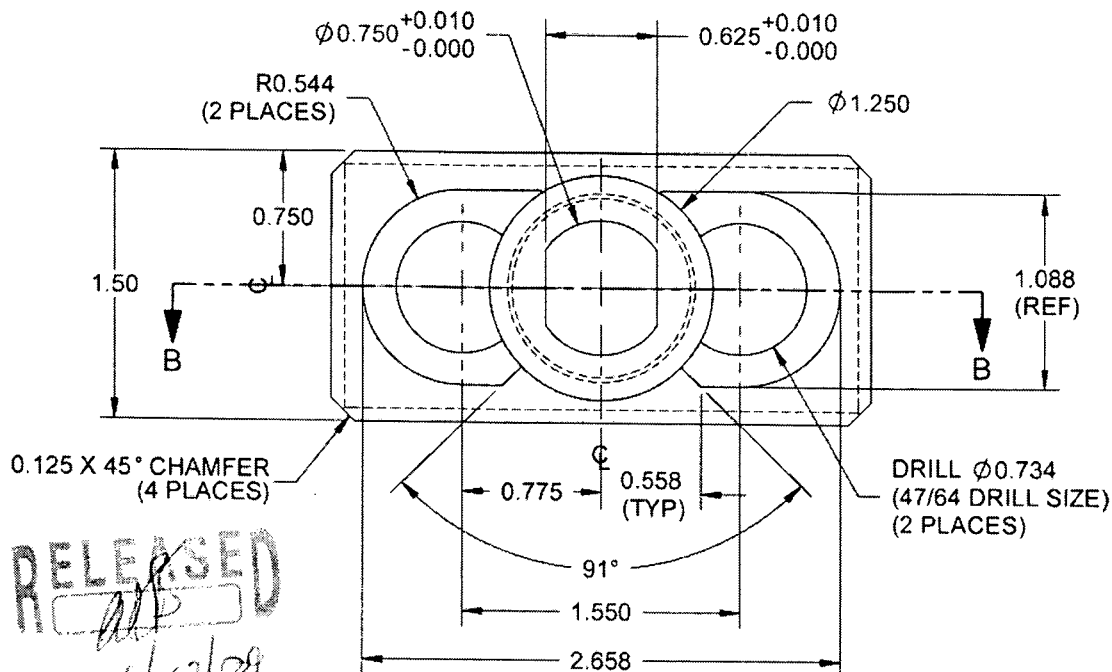
- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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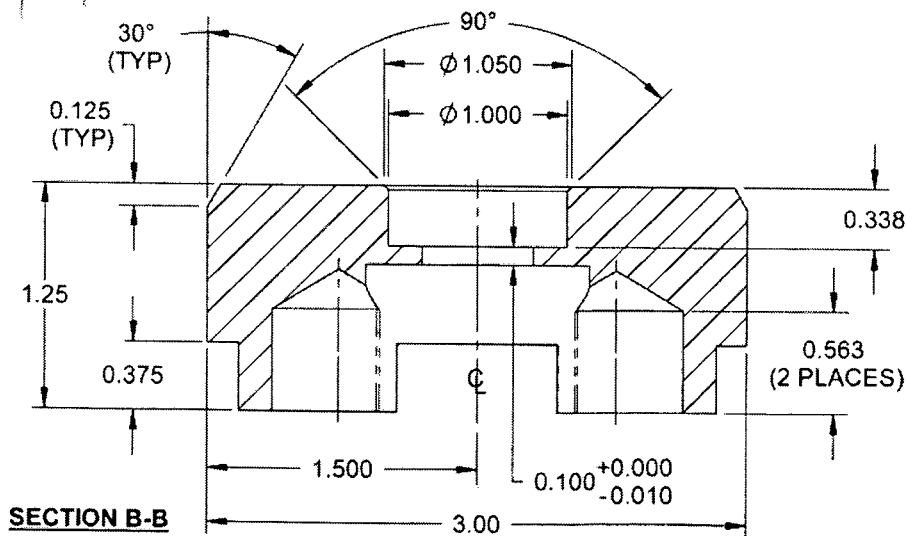


DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 17	APPROVED [Signature]	DRAWING NO. D3393	REV. A
DATE 05.02.09	TITLE BATTERY LOCK	SHEET 2 OF 3	
		SCALE 1:1	



RELEASED
05/03/09

Mo 44108



D3393-1 CASING

NOTES:

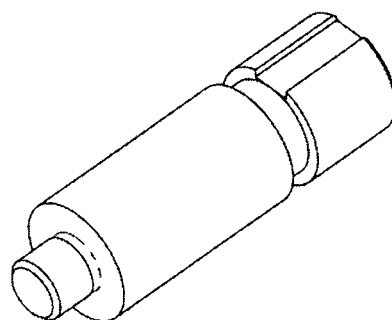
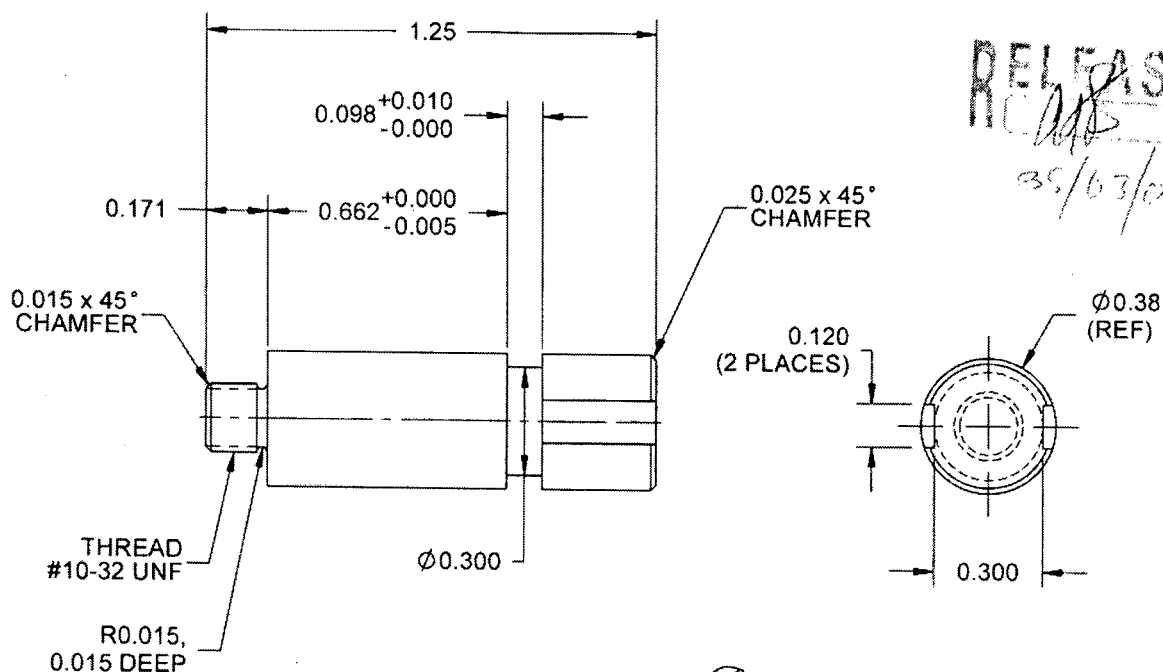
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A
DATE 05.02.09		TITLE BATTERY LOCK	SHEET 3 OF 3 SCALE 2:1



W/ 44108

D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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